Aero Design Ltd.

Work Order Control Sheet

Work Order#: 2015-91 **Date Opened:** 19-Aug-15 **Title:** Fabrication

Aircraft OEM: Eurocopter **Aircraft Model:** AS350/355 **Product Type:** Cargo Basket + Lid **Product Model:** Ski **Quantity:** 3

Work Order Contents

	Initial or N/A
Work Order/Build Sheets (Procedures Provided)	JR
Additional Work Sheets (Standard Practice)	N/A
Drawings (See List Below)	JR
Parts Distribution Sheet	JR
Sub Component Tags	N/A
Completed Certification	N/A
Time Sheet (R&D)	N/A
Notes	N/A

Build Sheet Contents

	Initial or N/A
Tasks Initialled	JC
Dual Inspections Initialled	JC

Drawing List

Drawing #	Rev #	Description	Initial or N/A
94011	1	Body	JR
94012	1	Lid	JR
94023	1	Att Hoop	JR
94030	1	Hoop	JR
70405	4	Lid Walkway	JR
70406	3	Front End Cutout	JR

Traveller

Initial or N/A

Component Completion

	As Instructed
Quantity Complete on This Work Order	3
Quantity Incomplete on This Work Order	0
Further Processing Required Before Release	N/A
Release to Stock as Components	N/A

Certification

	Initial or N/A
Form One Completed	N/A
Serviceable (Green) Tag Completed	N/A
In Process (Yellow) Tag Completed	N/A
Unserviceable (Red) Tag Completed	N/A
Parts Placed in Stores for Distribution	N/A

Additional Documentation

	Initial or N/A
Documentation of a minor change	N/A
Non-Conformance Report Required	N/A
Service Difficulty Report Required	N/A

Billing

	Initial or N/A
Local (Aero Design)	JC
Research and Development	N/A
Third Party	N/A

Work performed by:	Print: Jeff Clarke	Sign:		SCA: AD02	Date: 17-Sep-15
ICC / Dual Inspection preformed by:	Print: Jason Rekve	Sign:		SCA: AD01	Date: 17-Sep-15
Work Order closed by:	Print: Jeff Clarke	Sign:		SCA: AD02	Date: 17-Sep-15

2015-91
AS350 XL SKI x3
RH FRONT END CUTOUT

CARGO BASKET BODY FABRICATION - COMMON

General

These instructions apply to all cargo basket body assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only
69811, Revision 3 – Standard Low Mounted Basket
94511, Revision 0 – Extra-Wide Low Mounted Basket
94611, Revision 0 – Extra-Wide Low Mounted Ski Basket
76611, Revision 0 – High Mounted Ski Basket
Options 70404, Revision 2 – Front end cutout – 698
70411, Revision 0 – Front end cutout – 945/946

Eurocopter AS350/AS355 – left or right
77611, Revision 1 – Short Basket
76411, Revision 3 – Medium Basket (left or right)
78411, Revision 2 – Long Basket
94011, Revision 0 – Extra Large (ski) Basket
Options 70406, Revision 2 – Front end cutout – 764/776/784/940

Robinson R44 – left or right
90611, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only
80211, Revision 0 – Short Basket
80311, Revision 0 – Medium Basket
81111, Revision 0 – Long Basket
Options 70406, Revision 2 – Front end cutout – 802/803/811

Bell 429 – right or left
95911, Revision 0 – Standard Basket

Bell Medium – left or right
75111, Revision 0 – Standard Basket
95511, Revision 0 – Extra Large (ski) Basket
Options 70407, Revision 1 – Front end cutout – 751
704 , Revision – Front end cutout – 955

MD600
82811, Revision 0 – Standard Basket

Options – Applicable to all models
70403, Revision 5 – Auxiliary Latch

CARGO BASKET BODY FABRICATION - COMMON

Complete
(initial or SCA #)

Work Order: 2015-91

Date Open: 19 AUG 2015

1. Rim Assembly – Basket Body — JC.
    a. Cut and fit ¾" x 0.035 material to fit rim jig.
        i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
    b. Record material PO on attached material list.
    c. Remove writing on tubes with acetone and scotch bright.
    d. For extra large baskets – drill #30 (0.129) vent holes to vent stringer tubes into rims.
    e. *94611 (206L/407 XL ski) only* – drill for 4 threaded bushings before assembling rim.

2. Weld Rim Assembly. — AD-05
    a. Record welding rod PO on attached material list.
    b. *94611 (206L/407 XL ski) only* – weld 4 threaded bushings into inboard rim tube.

3. Inspection — JC.
    a. Rim for complete welds

4. Frame assembly – body — JC.
    a. General
        i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing, hoops, etc.)
    b. Grind corner welds from step 2 on rim to allow hoops to sit flat.
    c. Pull required hoops from stock - standard, attachment, handle.
        i. If hoops are not in stock see detailed procedure sheet for specific hoop fabrication.
        ii. Ensure vent hole is located at centre of tube to vent spine tubes.
    d. Assemble hoops with attachment lug locating jig and hoop spacing jig.
        i. Ensure correct order and orientation of hoops. Refer to drawing.
            1. Attachment lugs are on inboard side.
            2. Handle bracket bushings are on outboard side, second hoop from both ends. May be on attachment hoops.
        ii. Run 3/8-24 tap into attachment lugs to ensure clear threads.
        iii. Bolt attachment lug locating jig to attachment hoops with 3/8-24 bolts.
        iv. Attach inboard and outboard hoop spacing jigs to all hoops using 1" C-clamps. Raise jigs approximately 2" off table to allow room to weld around hoops.
        v. Attach bottom (spine) jig to all hoops using 1" C-clamps along the centre line of the basket. Ensure jig is straight prior to tightening all clamps.
    e. Cut ½" x 0.035 material to fit spine jig.
    f. Cut ½" x 0.035 material for strut to fit from lower inboard attachment to upper outboard rim.
        i. Refer to applicable drawing for position, not required on some baskets.
    g. *Option*: Cut ½" x 0.035 material for front end cutout. Record material PO on attached material list.
    h. *90611 (R44) only*: Cut ½" x 0.035 material to fit front end structure. Record material PO on attached material list.
    i. Drill vent holes into attachment hoop and/or rim to vent strut(s) and front end cutout.

j. Record hoop WOs and material POs on attached material list.
k. Remove writing on tubes with acetone and scotch bright.
l. Insert rim assembly into jig and set frame assembly onto rim. Ensure correct orientation of lid prop bushings in rim to frame. Bushing hole must be closer to attachment side.
m. Align hoops to rim in accordance with drawing. General positions:
    i. Extra large baskets
        1. inboard side of hoops (attachment side) aligns to OUTSIDE of rim
        2. outboard side of hoops (handle side) aligns to INSIDE of rim
        3. forward and aft hoops align to INSIDE of rim
    ii. All other baskets
        1. inboard side of hoops (attachment side) aligns to INSIDE of rim
        2. outboard side of hoops (handle side) aligns to INSIDE of rim
        3. forward and aft hoops align to INSIDE of rim, except R44

5. TIG weld frame to rim assembly. AD-05
    a. Ensure lug locating jig and hoop locating jigs are in place. Jigs must remain in place for as long as practical during welding.
    b. Strut tubes and front end cutout (see step 4.f. and g.) must be welded in place after the hoops are welded to the rim. Jig(s) must be in place prior to welding strut tubes.
    c. Robinson R44 (90611) requires fitting and welding of forward end after remainder of basket frame is welded. Use jig to support front hoop.
    d. Record welding rod PO on attached material list.

6. Inspection JC.
    a. Frame assembly for complete welds.

7. Mesh assembly. JC.
    a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
    b. Cut mesh to size for body.
    c. Remove surface rust with scotch-brite.
    d. Bend body mesh – use table with bend markings on top. Lock wheels on table.
        i. For extra wide baskets only –
            1. Set ¾" angle along edge of table under mesh sheet. Set 1.5" square tube on top of mesh aligned with angle on edge of table. Clamp in place with 6" C-clamps.
            2. Bend upper edge of sheet just past a cell intersection to make a flange 2.5" - 3.25" wide. Closer to 2.5" is preferred, full cell intersection on flange side at bend is required.
            3. Bend down by hand as far as possible, then use a hammer to flatten the bend tight against the angle on the edge of the table.
        ii. Using markings on table, align sheet to indicated edge.
        iii. Using markings on table, align 3" tube to required position and clamp tube in place.
        iv. Bend mesh by hand tightly over tube along length of tube.
        v. Keeping mesh in place, un-clamp 3" tube, move to other position and clamp tube in place.
        vi. Bend mesh by hand tightly over tube along length of tube.
    e. Install attachment lug jig onto basket frame.

f. Ensure end struts are welded in basket frame if required by the drawing.
g. Insert mesh into basket.
    i. General
        1. Some cells may interfere with correct positioning, especially at the upper corners and around struts. Bend cell(s) in as required, do not cut cells off.
        2. Ideally welds will be located on mesh intersections. Shift mesh if possible to minimize welds located off mesh intersections.
        3. Ensure mesh reaches all edges of basket BEFORE trimming. Regardless of progress in clamping, remove clamps and shift mesh if required.
        4. Ensure cleco clamps are placed from the inside of the basket to allow removal during welding. Cleco clamps may be used from the outside during fitting, but must be removed prior to welding.
    ii. Extra large baskets only – seat corner of mesh with flange into inboard upper corner of frame. Use C-clamps on edge of flange as required to maintain tight fit.
    iii. Starting at inboard top edge of basket, clamp mesh to hoop near top rim using cleco clamps onto hoops. For regular size baskets, edge of mesh should sit approximately half way up rim tube.
    iv. Working down the inboard side, clamp mesh to hoops with cleco clamps. Clamp down into radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, two clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
    v. Clamp mesh to spine in at least 1 place per section.
    vi. Working up the outboard side, clamp the mesh into the radius of hoop and continue clamping as required to maintain tight fit in corner of hoop. After the corners are tight, 2 clamps just onto the radius on both ends should be sufficient to hold the corner tight, remove all extra clamps.
    vii. Trim upper outboard edge of mesh if required, edge of mesh must be low enough on rim tube to prevent the weld from protruding above the edge of the rim. Some sheets are tapered and may require ½ to 1 cell to be removed over some or all of the length of the basket. De-burr cut edges with a sanding disc on a die-grinder. Straighten cut cells with duck-bill pliers. Clamp mesh near upper edge to hoops with cleco clamps after trimming.
    viii. Trim ends to land on hoops, at mesh intersections if possible.
h. Cut mesh to fit ends. Record material PO on attached material list.
    i. Remove surface rust with scotch-brite.
    ii. Ensure mesh is cut at intersections where possible.
    iii. Bend top edge of mesh 1/8"-3/16" down at 45 degrees
    iv. Cut for front end cutout if required.
i. 90611 (R44) only: Cut mesh to fit upper forward end. Record material PO on attached material list.
    i. Remove surface rust with scotch-brite.
    ii. Ensure mesh is cut at intersections where possible.
    iii. Bend top edge of mesh 1/4" down at 60 degrees.
    iv. Fit mesh to front end of basket.

8. Weld mesh to frame assembly per drawing. AD-05
    a. Ensure lug locating jig is in place prior to welding.
    b. General welding requirements for all baskets, MIG welding:
        i. Every intersection at top edges.
        ii. Every intersection at ends.
        iii. First 5 intersections down on hoops, then every second intersection.
        iv. Every intersection along spine.
        v. Extra large baskets – every intersection along corner.
        vi. Every intersection around ends
        vii. Every intersection along struts (if applicable)
    c. Bend and trim cells bent in to fit mesh as required and weld in position.
    d. Grind high spots off body mesh welds on ends before welding end mesh.
    e. *90611 (R44) only* – weld lid prop bushing (step 9) into rim BEFORE welding upper mesh on forward end of basket assembly.
    f. Record welding rod PO on attached material list.

9. Weld basket components AD-05
    a. TIG weld lid prop bushing(s), one or two per drawing.
        i. Record welding rod PO on attached material list.
        ii. Record lip prop bushing WO on attached material list.
    b. TIG weld caps to close top of 1" hoops as applicable.
    c. 94611 (Bell206L/407 XL ski) only: cut rim over cross tube gap.
        i. Cut inboard rim on aft end. Grind flush with hoops.
        ii. TIG weld caps on open tubes.
        iii. Record cap material PO on attached material list.
    d. 95911 (Bell 429) only: placard bracket to forward upper corner of basket.
        i. Record welding rod PO on attached material list.
        ii. Record placard bracket WO on attached material list.

10. Clean up JC.
    a. Grind high spots off mesh welds.
    b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out. Do not tighten in corners of hoops, mesh will be deformed.
    c. Drill #9 through lid prop bushing(s). De-burr hole(s).
    d. Remove surface rust with scotch-brite pad.

11. Final Inspection _____
    To be completed by a different person than the previous steps.
    a. Basket body assembly for complete welds, and required minimum mesh weld locations.
    b. Filled vent holes – usually on hoops
    c. Overall condition and conformity to drawing(s).
        i. Hoops for height.
        ii. Rim for width and length and alignment.
        iii. Lid prop lugs in correct ends.
        iv. Fore/aft strut in hoop if required by drawing.
    d. Material lists complete.

e. Tag complete basket body assembly in preparation for powder coating.

12. Powder Coating _____
    a. Parts are to be powder coated white in accordance with commercial practices.
    b. Record powder coating PO.
    c. Inspect powder coating on receiving.
    d. Tag basket body assembly and place into stock in preparation for assembly.

2015-91
AS350 XL SKI x3
WALKWAY

CARGO BASKET LID FABRICATION - COMMON

General

These instructions apply to all cargo basket lid assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only
69812, Revision 3 – Standard Low Mounted Basket; Extra-Wide Low Mounted Basket
94612, Revision 0 – Extra-Wide Low Mounted Ski Basket
76612, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right
77612, Revision 1 – Short Basket
69812, Revision 3 – Medium Basket (left and right)
78412, Revision 2 – Long Basket
→ 94012, Revision 0 – Extra Large (ski) Basket

Robinson R44 – left or right
90612, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only
80212, Revision 0 – Short Basket
80312, Revision 0 – Medium Basket
81112, Revision 0 – Long Basket

Bell 429 – right or left
95912, Revision 0 – Standard Basket

Bell Medium – left or right
75112, Revision 0 – Standard Basket
95512, Revision 0 – Extra Large (ski) Basket

MD600
82812, Revision 0 – Standard Basket

Options
→ 70405, Revision 3 – Walkway
70402, Revision 1 – Lid Door

CARGO BASKET LID FABRICATION

Complete
(initial or SCA #)

Work Order: 2015-91

Date Open: 19 AUG 2015

1. Rim Assembly – Basket Lid — JC.
    a. Cut and fit ¾" x 0.035 material to fit rim jig, 45 degree ends.
        i. 1 or 2 lid prop bushing holes in short tube – refer to drawing
    b. Record material PO on attached material list.
    c. Remove writing on tubes with acetone and scotch bright.

2. Weld Rim Assembly — AD-05
    a. Record welding rod PO on attached material list.

3. Inspection — JC.
    a. Rim for complete welds

4. Frame assembly – Lid — JC.
    a. General
        i. Vent holes shall be #30 (0.129), and located inside the structure wherever possible to allow venting of weld gasses through existing holes (i.e. lid prop bushing)
    b. Insert rim from step 2 into jig.
    c. Cut and fit ¾" x 0.035 material, 21" long, for lid cross members.
    d. Record material PO on attached material list.
    e. Remove writing on tubes with acetone and scotch bright.
    f. Drill vent holes into rim to vent cross members into rim.
    g. Locate cross members in lid rim. Refer to drawing for spacing of cross members. Clamp cross members with C-clamps to jig.

5. Frame assembly – Lid with optional walkway modification — JC.
    a. Fit cross members to rim in accordance with step 4.
    b. Attach walkway jig with C-clamps. Ensure correct orientation of rim, refer to drawing.
    c. Cut ½" x 0.035 material for walkway stringers to fit between lid cross members. Record material PO on attached material list.
    d. Drill vent holes into cross members at walkway stingers.
    e. Align walkway stringers on walkway jig using cleco clamps near both ends of each stringer, and clamp stringer to jig using a C-clamp in the centre.

6. Weld frame assembly. — AD-05
    a. Record welding rod PO on attached material list.
    b. Jigs must remain in place for as long as practical during welding.

7. Inspection — JC.
    a. Frame assembly for complete welds.

CARGO BASKET LID FABRICATION **Complete** (initial or SCA #)

8. Mesh assembly. JC.
   Note: 95912 (Bell 429) does not have mesh. Skip to step 10.
   a. Pull sheet of expanded mesh from stock. Record material PO on attached material list.
   b. Cut mesh to size for lid.
   c. Remove surface rust with scotch-brite.
   d. Ensure lid is prepared for mesh on the correct side.

9. Weld mesh to frame assembly per drawing. AD-05
   a. General welding requirements for all lids:
      i. Every intersection on all edges.
      ii. First 5 intersections along cross members, then every second intersection.
   b. MIG weld both short sides.
   c. Clamp lid over spacer at centre of lid to pre-tension mesh.
      i. ¾" for lids under 76"
      ii. 1" (check) for lids over 76"
   d. Weld remainder of mesh as indicated in a.
   e. Record welding rod PO on attached material list.

10. Weld lid components. AD-05
   a. Handle brackets, locate in accordance with drawing.
      i. Standard location: ¼" outside of last cross member on both ends.
      ii. Record handle bracket WO and welding rod PO on attached material list.
   b. Lid prop bushing(s).
      i. one or two in accordance with drawing.
      ii. Record lip prop bushing WO and welding rod PO on attached material list.
   c. Placard bracket. – not installed on 95912 (Bell 429)
      i. Locate on cross member to set bracket in centre bay of lid.
      ii. Record placard bracket WO and welding rod PO on attached material list.

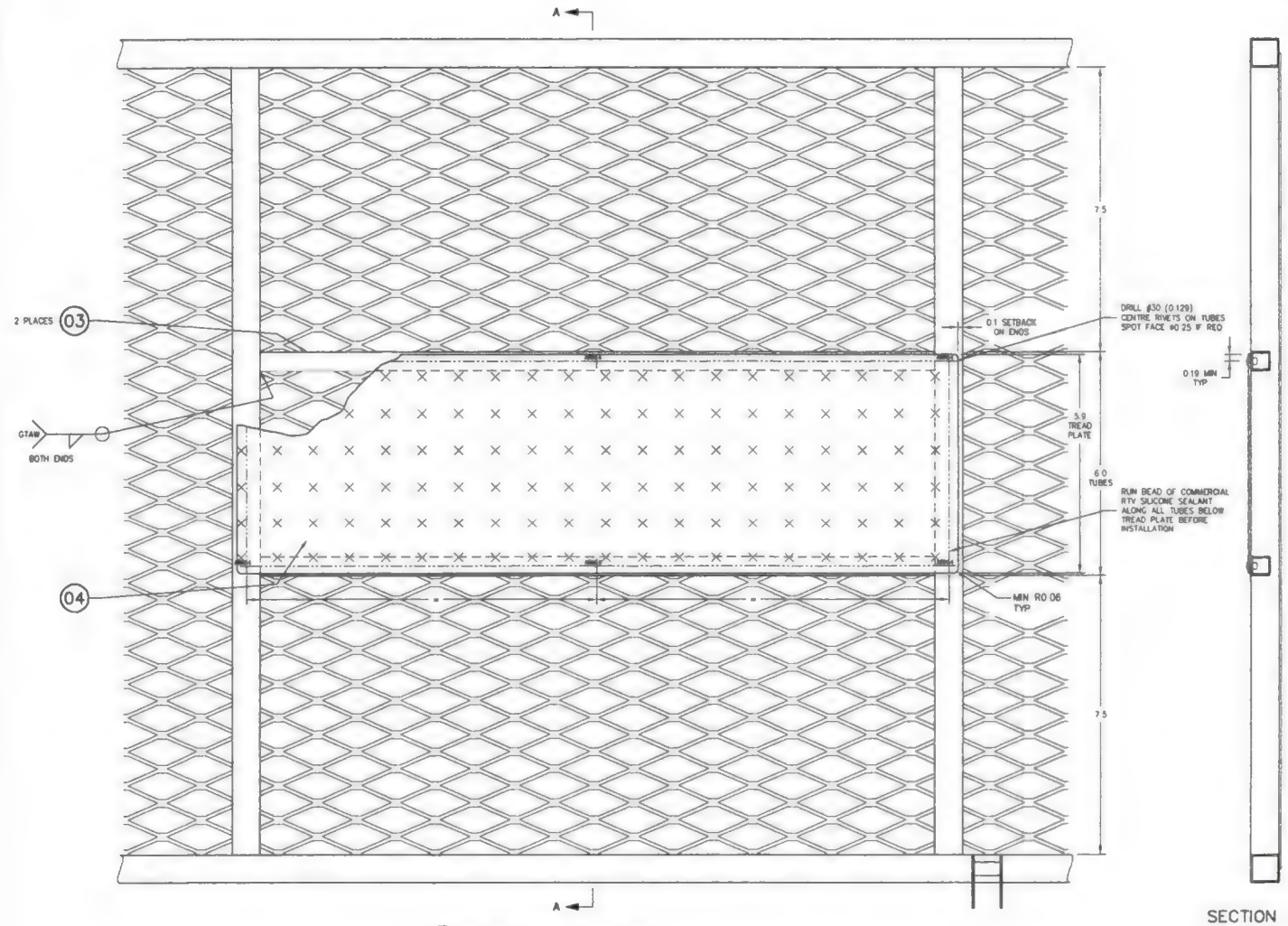
11. Clean up JC.
   a. Grind high spots off mesh welds.
   b. Tighten mesh using special pliers. Tighten enough to remove "oil canning", where mesh springs in or out.
   c. Straighten lid using frame attached under welding table. Work carefully, avoid excessive force to prevent kinking rim tubes.
   d. Drill #9 through lid prop bushing(s). De-burr hole(s).
   e. Drill for lid bumpers using 1/4" (#3) centre drill.
      i. 3 places for lids under 76"
      ii. 4 places for lids over 76"
   f. Remove surface rust with scotch-brite pad.

12. Final Inspection
   To be completed by a different person than the previous steps. _____
   a. Basket lid assembly for complete welds, and required minimum mesh weld locations.
   b. Material lists complete.
   c. Overall condition and conformity to drawing(s).

13. Powder Coating
    a. Parts are to be powder coated white in accordance with commercial practices.
    b. Record powder coating PO.
    c. Inspect powder coating on receiving.
    d. Tag lid assembly and place into stock in preparation for assembly.

2015-91

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL MEDIUM AND EUROCOPTER AS350 BASKETS CHANGE TUBES	BJC	MAR 19/08
2	ADD EUROCOPTER EC135 MCDONNELL DOUGLAS MD500N BELL 206B BASKETS	BJC	DEC 4/08
3	ADD NEW AS350 AND 206L/407 MODELS	BJC	DEC 4/08
4	TITLE BLOCK UPDATED, MODEL LIST REMOVED, ADD ALT RIVET, ADD NOTE 7	BJC	29/05/2014



01 BASKET LID ASSEMBLY

SECTION A-A

NOTES:

1. THIS DRAWING IS AN OPTIONAL CONFIGURATION ADDING A TREAD PLATE STEP TO THE LID. THIS CONFIGURATION MAY BE APPLIED TO ANY OR ALL BAYS OF THE LID. REMAINDER OF LID ASSEMBLY IS TO BE FABRICATED IN ACCORDANCE WITH THE APPLICABLE DRAWINGS
2. TUBES (ITEM 03) MUST BE WELDED IN PLACE BEFORE MESH IS WELDED ON BOTTOM
3. REMOVE ALL BURRS AND BREAK SHARP EDGES.
4. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT
5. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
6. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY. INSTALL TREAD PLATE AFTER POWDER COATING
7. WIDTH AND POSITION OF LID STEP MAY BE ADJUSTED TO MATCH LID DOOR INSTALLED IN ACCORDANCE WITH DRAWING 70402 ON ADJOINING BAY OF THE LID.

A/R						
	CR3213-4-02		BLIND RIVET	ALTERNATE: MR3213-4-02		
1	70405-04	04	TREAD PLATE	ALUMINUM	COMMERCIAL	0.063 TREAD PLATE
2	70405-03	03	TUBE	4130 STEEL COND N	MIL-T-6736	0.5 x 0.035 WALL TUBE
1	SEE NOTE 1	02	BASKET LID ASSEMBLY			
\	70405-01	01	BASKET LID ASSEMBLY - MODIFIED WITH STEP			
01	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					

BASIC CODE REF: NAS 523

DASH NO FOR DIAMETER
N=MFD HEAD NEAR SIDE
F=MFD HEAD FAR SIDE

C=COUNTERSINK
D=DIMPLE
DIGIT=# OF SHEETS TO BE DIMPLED

DASH NO FOR LENGTH

BASIC CODES
BJ = MS20470AD
BB = MS20426AD
ARN = CR3213
ARM = CR3212

INSTALL NEW RIVET
REMOVE/REPLACE RIVET
EXISTING RIVET

APPROVALS		DATE
DRAWN	JEFF CLARKE	21 SEPT 2005
CHECKED	E BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON:
DECIMALS: X .XXX ±0.010; X .XX ±0.03; X .X ±0.1
ANGLES ±1/2°

AERO DESIGN LTD.
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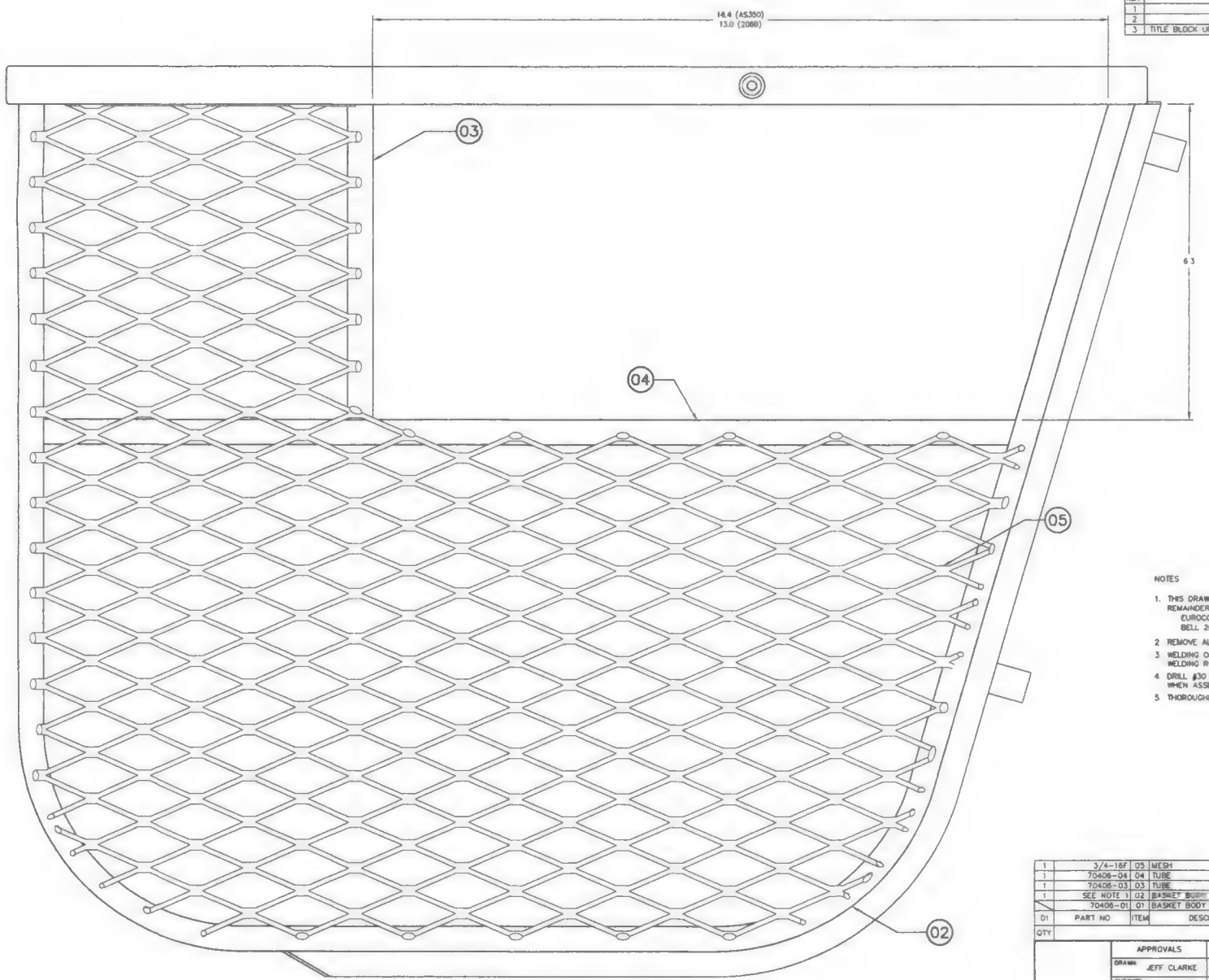
CARGO BASKET
LID STEP MODIFICATION

SCALE 1 : 15	DWG SIZE	DWG NO	REV
SHEET 1 OF 1	A1	70405	4

2015-91

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL 206B	BJC	DEC 22/08
2	MODIFY OPENING	BJC	OCT 27/11
3	TITLE BLOCK UPDATED, LONG/EXTRA LARGE CONFIGURATION ADDED TO SHT. 2	BJC	14/07/2014



(01) BASKET BODY ASSEMBLY

EUROCOPTER AS350 LONG SHOWN
EUROCOPTER AS350 EXTRA-LARGE SIMILAR

NOTES

1. THIS DRAWING IS AN OPTIONAL CONFIGURATION FOR THE FORWARD END ONLY
   REMAINDER OF BASKET IS TO BE IN ACCORDANCE WITH THE FOLLOWING DRAWING:
   EUROCOPTER AS350/AS355: 78411 (LONG) OR 94011 (EXTRA LARGE)
   BELL 206B: 81111 (LONG)
2. REMOVE ALL BURRS AND BREAK SHARP EDGES
3. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C
   WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT
4. DRILL ⌀30 (0.129) HOLES TO VENT TUBES INTO BASKET HOOP AND/OR RIM
   WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD
5. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY

QTY	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
			LIST OF MATERIALS			
01	70406-01	01	BASKET BODY ASSEMBLY - MODIFIED FORWARD END			
1	SEE NOTE 1	02	BASKET BODY ASSEMBLY			
1	70406-03	03	TUBE	4130 STEEL COND N	MIL-T-6736	0.5 x 0.035 WALL TUBE
1	70406-04	04	TUBE	4130 STEEL COND N	MIL-T-6736	0.5 x 0.035 WALL TUBE
1	3/4-16F	05	MESH	MILD STEEL	COMMERCIAL	

APPROVALS		DATE
DRAWN	JEFF CLARKE	19 MAR 2008
CHECKED	E BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON:
DECIMALS: X.XXX ±0.010; X.XX ±0.03; X.X ±0.1
ANGLES ±1/2°

AERO DESIGN LTD.
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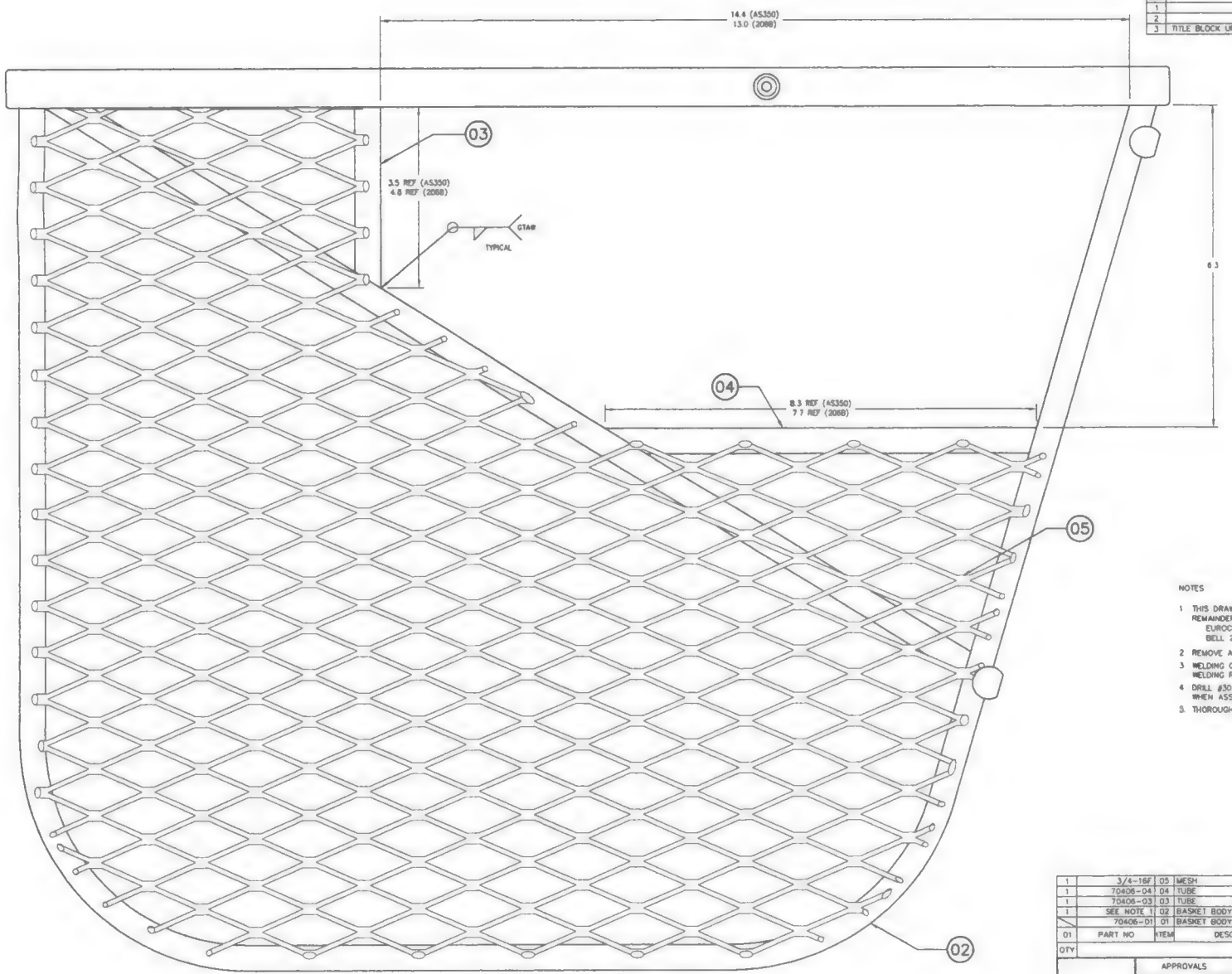
POWELL RIVER, BC, CANADA, V8A 0G3
TEL. 604.485.2276 www.aerodesign.ca

QUICK RELEASE CARGO BASKET
OPEN FORWARD END MODIFICATION

SCALE 1 : 1	DWG SIZE	DWG NO.	REV
SHEET 2 OF 2	A1	70406	3

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
1	ADD BELL 206B	BJC	DEC 22/08
2	MODIFY OPENING	BJC	OCT 27/11
3	TITLE BLOCK UPDATED, LONG/EXTRA LARGE CONFIGURATION ADDED TO SHT 2	BJC	14/07/2014



N/A

NOTES

1. THIS DRAWING IS AN OPTIONAL CONFIGURATION FOR THE FORWARD END ONLY. REMAINDER OF BASKET IS TO BE IN ACCORDANCE WITH THE FOLLOWING DRAWING.
   EUROCOPTER AS350/AS365: 76411 (MEDIUM) OR 77811 (SHORT)
   BELL 206B: 80211 OR 80311
2. REMOVE ALL BURRS AND BREAK SHARP EDGES
3. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT
4. DRILL ø30 (0.129) HOLES TO VENT TUBES INTO BASKET HOOP AND/OR RIM WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD
5. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY

(01) BASKET BODY ASSEMBLY

EUROCOPTER AS350 SHORT/MEDIUM SHOWN
BELL 206B SIMILAR

LIST OF MATERIALS

QTY	PART NO	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	3/4-16F	05	MESH	MILD STEEL	COMMERCIAL	
1	70406-04	04	TUBE	4130 STEEL COND N	MIL-T-6736	0.5 X 0.035 WALL TUBE
1	70406-03	03	TUBE	4130 STEEL COND N	MIL-T-6736	0.5 X 0.035 WALL TUBE
1	SEE NOTE 1	02	BASKET BODY ASSEMBLY			
	70406-01	01	BASKET BODY ASSEMBLY - MODIFIED FORWARD END			

APPROVALS		DATE
DRAWN	JEFF CLARKE	19 MAR 2008
CHECKED	E. BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON.

DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	

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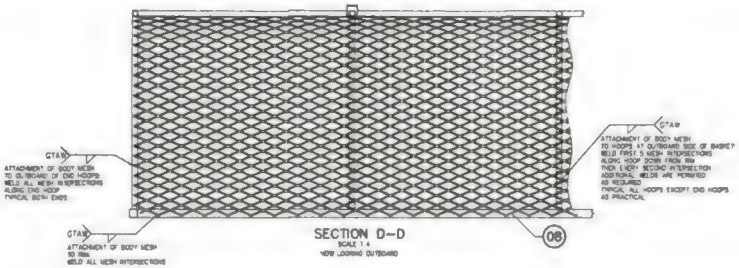
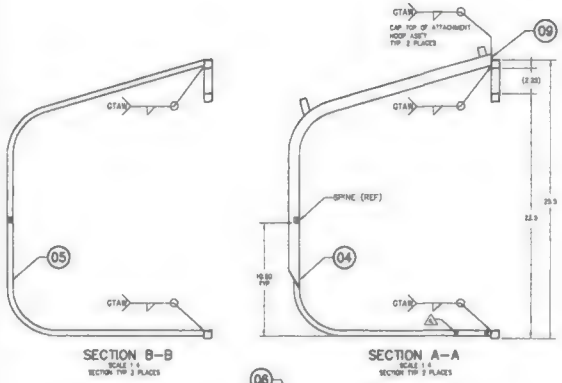
QUICK RELEASE CARGO BASKET
OPEN FORWARD END MODIFICATION

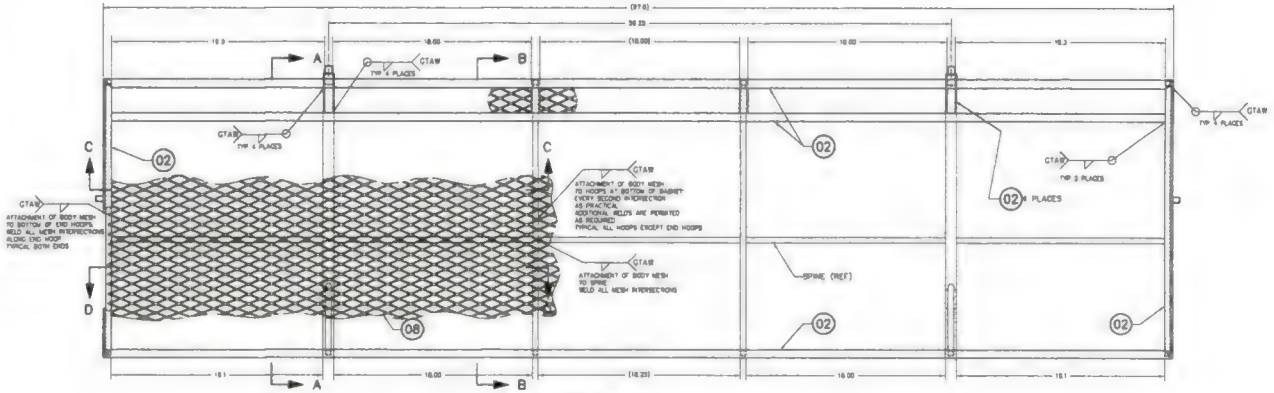
SCALE 1 : 1	DWG SIZE	DWG NO.	REV
SHEET 1 OF 2	A1	70406	3

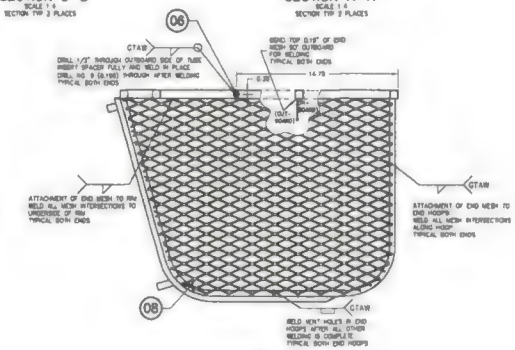
2015-91

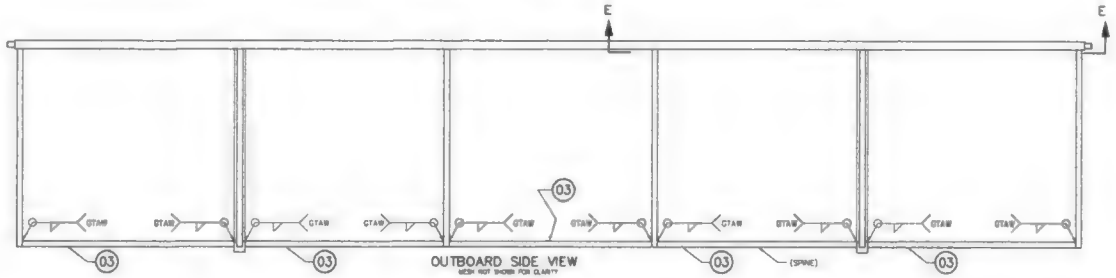
REV	DESCRIPTION OF CHANGE	INITIALS	DATE
	INITIAL ISSUE		
1	TITLE BLOCK UPDATES, WELDING ROD UPDATES, REFERENCE DWGS ADDED	BJC	11/07/2014
	ITEM NUMBERS UPDATED, WELDS DOWN SIDES INCREASED		



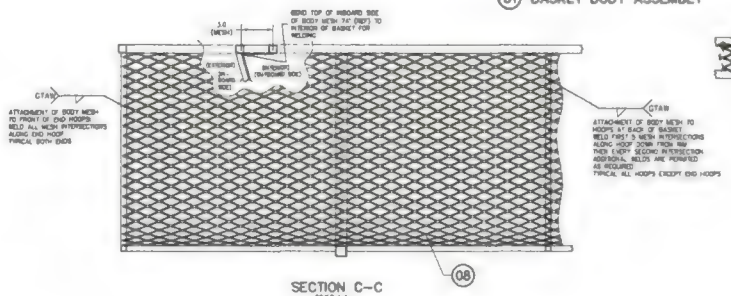


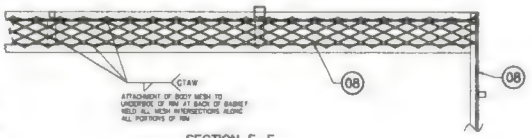






01 BASKET BODY ASSEMBLY





NOTES:
1. REMOVE ALL BURRS AND BREAK SHARP EDGES
2. PRIOR TO WELDING, DRILL Ø.20 (5.129) VENT HOLES IN ASSEMBLY FOR VENTING OF WELD GASES. WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD.
3. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C
   4130 AND 1018 STEEL: WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT
   STAINLESS AND 4130 STEEL: WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT
4. INSTALL ITEM 7 (BASKET HANDLE PROVISIONS ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD DRAWING 84282 BEFORE WELDING HOOPS TO RIM
5. FINISH: THOROUGHLY CLEAN AND POWDER COAT BASKET ASSEMBLY

ITEM	PART NO.	QTY	DESCRIPTION	MATERIAL/NOTE	MATERIAL SPEC	STOCK SIZE
			LIST OF MATERIALS			
8	--	00	CAP	MILD STEEL	AMS 1010/1020	0.050 SHEET
A/R	3/4 - 16F	08	MESH	MILD STEEL	COMMERCIAL	
7	84282	07	BASKET HANDLE PROVISIONS ASSEMBLY			
6	48215	06	SPACER			
5	84030	05	HOOP			
4	94013	04	ATTACHMENT HOOP			
A/R	-	03	SQUARE TUBE	4130 STEEL COND N	MIL-T-6736	1/2 X 0.035 SQR TUBE
A/R	-	09	SQUARE TUBE	4130 STEEL COND N	MIL-T-6736	3/4 X 0.035 SQR TUBE
01	94011-01	01	BASKET BODY ASSEMBLY			

APPROVALS		DATE
DRAWN	K. RATHNELL	03 AUG 11
CHECKED	E. BURDON	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON:
DECIMALS: X.XXX ±0.010, X.XX ±0.03, X.X ±0.1
ANGLES: ±1/2°

AERO DESIGN LTD.
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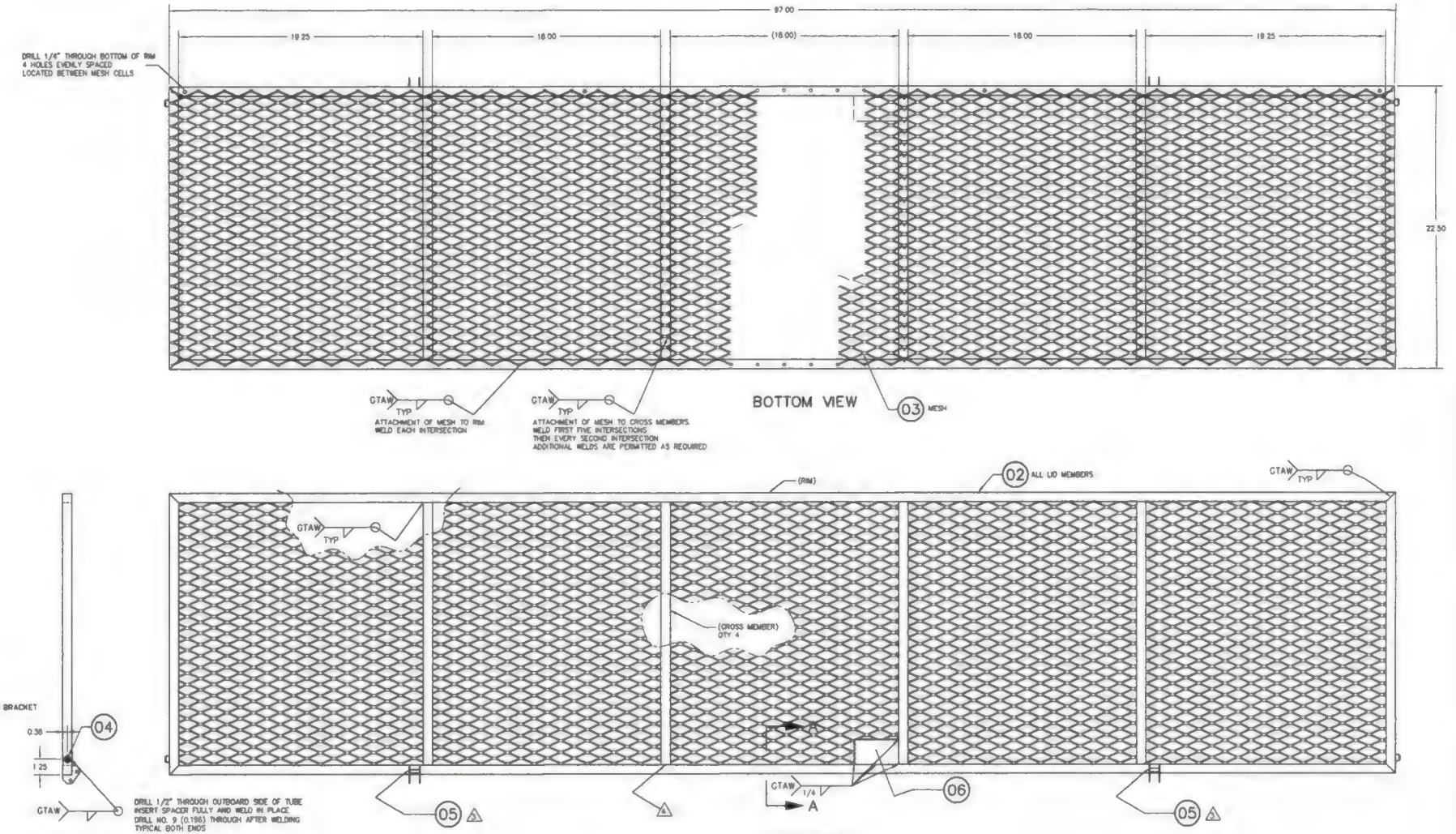
EUROCOPTER AS350 & AS355 SERIES
QUICK RELEASE CARGO BASKET
BASKET BODY ASSEMBLY (EXTRA LARGE)

SCALE: 1:4	SIZE: A0	DWG. NO.: 94011	REV: 1
SHEET 1 OF 1			

2015-91

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED. CHANGED 36273-01 TO 84263-01. ITEM #'S ADDED	BJC	10/07/2014
	WELDING ROD UPDATED. # OF WELDS DOWN BRACE TUBES INCREASED		



01 LID ASSEMBLY

NOTES:
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C
   4130 AND 1018 STEEL. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT
   STAINLESS AND 4130 STEEL. WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT
3. INSTALL ITEM 5 (LID HANDLE PROVISIONS ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING 84263
4. DRILL #30 (0.129) HOLES IN LONG TUBE MEMBERS AT BRACE LOCATIONS TO VENT WELD GASSES. WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD
5. FINISH: THOROUGHLY CLEAN AND POWDER COAT LID ASSEMBLY

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
			LIST OF MATERIALS			
1	36204-10	06	PLACARD BRACKET			
1	84263-01	05	LID HANDLE PROVISIONS ASSEMBLY			
2	49216-01	04	SPACER			
A/R	3/4 - 16F	03	MESH	MILD STEEL	COMMERCIAL	
A/R		02	SQUARE TUBE	4130 STEEL COND. N	MIL-T-6736	0.75 X 0.035 SQR TUBE
	94012-01	01	LID ASSEMBLY			

APPROVALS		DATE
DRAWN	R RATHWELL	05 AUG 11
CHECKED	E BURGOIN	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON.
DECIMALS: X.XXX ±0.010; X.XX ±0.03; X.X ±0.1
ANGLES: ±1/2°

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EUROCOPTER AS350 & AS355 SERIES
QUICK RELEASE CARGO BASKET
LID ASSEMBLY (EXTRA LARGE)

SCALE	DWG SIZE	DWG NO	REV
1 : 4	A1	94012	1
SHEET 1 OF 1			

Work Order: 2015-91

Date Opened: 19 AUG 2015

Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Basket Body Fabrication

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	3	94011	**94011-01**	**Basket Assembly**		
Step 1				*Rim Assembly*		
	. 2		--	3/4" Tube - Long Rim (97")	4130 Steel, ¾" x 0.035 Sqr. Tube	14099
	. 2		--	3/4" Tube - Short Rim (25.5")	4130 Steel, ¾" x 0.035 Sqr. Tube	14099
	. 1		--	3/4" Tube - Long Stringer (95.5")	4130 Steel, ¾" x 0.035 Sqr. Tube	14099
	. 4		--	3/4" Tube - Short Stringer (2.25")	4130 Steel, ¾" x 0.035 Sqr. Tube	14099
Step 2				*Weld Rim Assembly*		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	14005
Step 3				*Inspection - Rim*	*None*	
Step 4				*Frame Assembly*		
	. 4		94030-01	Hoop - standard	4130 Steel, ½" x 0.035 Sqr. Tube	~~14~~ 2015-74
	. 2		94023-01	Hoop - attachment		2015-74
	. 5		--	1/2" Tube - spine	4130 Steel, ½" x 0.035 Sqr. Tube	14099
Step 4.g.		70406	70406-01	*Option: Front End Cutout*		
			70406-03	1/2" Tube	4130 Steel, ½" x 0.035 Sqr. Tube	14099
			70406-04	1/2" Tube	4130 Steel, ½" x 0.035 Sqr. Tube	14099
Step 5				*Weld Frame Assembly*		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	14005
Step 6				*Inspection - Frame Assembly*	*None*	
Step 7				*Mesh Assembly*		
	. 1		--	Mesh (Body - 56" x 96")	3/4-16F Expanded Mild Steel sheet	15037
	. 2		--	Mesh (End - 25" x 18")	3/4-16F Expanded Mild Steel sheet	15037

Work Order: 2015-91

Date Opened: 19 AUG 2015

Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Basket Body Fabrication

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 8				*Weld Mesh*		
	. A/R		--	Welding Rod	ER70S-6 MIG Wire	15059
Step 9				*Weld Basket Components*		
	. 2		49215-01	Spacer (Lid prop)	304 Stainless Steel, ½" Dia.	2015-84
	. A/R		--	Welding Rod	ER308L TIG Rod	14028
Step 10				*Clean Up*	*None*	
Step 11				*Inspection - Final Assembly*	*None*	
Step 12				Powder Coating		

Work Order: 2015-91

Date Opened: 19 AUG 2015

Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Lid Fabrication

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	3	94012	**94012-01**	**Lid Assembly**		
Step 1				*Rim Assembly*		
	. 2		--	3/4" Tube - Long Rim (97")	4130 Steel, ¾" x 0.035 Sqr. Tube	14099
	. 2		--	3/4" Tube - Short Rim (22.5")	4130 Steel, ¾" x 0.035 Sqr. Tube	14099
Step 2				*Weld Rim Assembly*		
	. A/R			Welding Rod	ER70S-2 TIG Rod	14005
Step 3				*Inspection - Rim*	*None*	
Step 4				*Frame Assembly*		
	. 4		--	3/4" Tube - Cross Member (21")	4130 Steel, ¾" x 0.035 Sqr. Tube	14099
Step 5		70405		*Option: Frame Assembly - with walkway*		
	. 10		--	1/2" Tube - walkway	4130 Steel, ½" x 0.035 Sqr. Tube	14099
Step 6				*Weld Frame Assembly*		
	. A/R			Welding Rod	ER70S-2 TIG Rod	14005
Step 7				*Inspection - Frame Assembly*	*None*	
Step 8				*Mesh Assembly*		
	. 1		--	Mesh (lid - 96" x 22")	3/4-16F Expanded Mild Steel sheet	15037
Step 9				*Weld Mesh*		
	. A/R			Welding Rod	ER70S-6 MIG Wire	15059

Work Order: 2015-91

Date Opened: 19 AUG 2015

Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Lid Fabrication

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 10				*Weld Lid Components*		
	. 1	84262	84262-01	Upper Handle Bracket Assembly		2014-38
	. . 4		36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	
	. . 2		36275-02	Support	304 Stainless, 5/16" Rod	
	. A/R			Welding Rod	ER308L TIG Rod	
	. 2		49216-01	Spacer (Lid prop)	304 Stainless, ½" Dia.	2015-84
	. A/R			Welding Rod	ER308L TIG Rod	14028
	. 1		36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	1506 1
	. A/R			Welding Rod	ER70S-2 TIG Rod	14005
Step 11				*Clean Up*		
Step 12				*Inspection - Final Assembly*		
Step 13				Powder Coating		

Aero Design

Parts Distribution Sheet

Description: A350 XL SKI FAB x3 WO# 205-91

From PO or WO #	Quantity	Description	Part Number	For WO #
		SEE MATERIAL TRACKING SHEETS		